to Rev B Drawing 5/14/8/27

# Work Order ID 119300

*May-15-14 12:35:44 PM*

*119300*

~~PRELIMINARY ISSUE~~



**Item ID:** D2261-041 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** ~~PRELIM~~ Released **Stop** *NS2*

**Item Name:** Long Arm Assembly

**Start Date:** 5/15/14 **Start Qty:** 1.00 *1*

**Required Date:** 5/15/14 **Req'd Qty:** 1.00 *1*

**Reference:**

**Cust Item ID:**

**Customer:**

**Run Start** *NR1*

**Stop** *NR2*

**Approvals:** **Process Plan:** MCS **Date:** 14-05-15 **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** | **Revision Nbr** | | | | | | | | |
| D2261 | ~~pb1~~ Rev B 5/14/8/27 | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | NC BRAKE | | | | | 1 | | | FF 14-05-16 |
| Brake NC | **Memo** | 0.00 | | | | | | | |
| Brake NC | Cut and Punch tube | | | | | | | | |
| | Form tube as per dwg D2261 | | | | | | | | |
| | Deburr and remove all marking. | | | | | | | | |
| 110 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *110* | | | | | | 1 | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS 27 9-89 14/5/16

**Item ID:** D2261-041 **Accept** *N9000040100* **Setup Start** *NS1*
**Revision ID:** PRELIM **Stop** *NS2*
**Item Name:** Long Arm Assembly

**Start Date:** 5/15/14 **Start Qty:** 1.00 *1*
**Required Date:** 5/15/14 **Req'd Qty:** 1.00 *1*
**Reference:**

**Cust Item ID:**
**Customer:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*
**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 120 | Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 | 0.00 | | | | 1 | 0 | 14-5-20 | DAS 34 9-89 |
| *120* | M126778 | | | | | | | | |
| Powdercoat | **Memo** | 0.00 | | | | | | | |
| Powder Coating | START TIME: 10:50 OVEN TEMPERATURE: 350 FINISH TIME: 11:20 | | | | | | | | |
| 130 | QC3- Inspect Part Finish | 0.00 | | DAS 30 9-89 | | 1 | | | 14/06/04 |
| *130* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | Small Fab | | | | | 1 | | FF | 14-06-04 |
| Small Fab | **Memo** | 0.00 | | | | | | | |
| Small Fab | Assemble as per dwg D2261 | | | | | | | | |

**Item ID:** D2261-041
**Revision ID:** PRELIM
**Item Name:** Long Arm Assembly

**Accept** *N9000040100*

**Setup Start** *NS1*
**Stop** *NS2*

**Start Date:** 5/15/14 **Start Qty:** 1.00 *1*
**Required Date:** 5/15/14 **Req'd Qty:** 1.00 *1*
**Reference:**

**Cust Item ID:**
**Customer:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 150 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *150* | | | | | | D | 14-06-04 | | DAS 9 9-89 |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 160 | Identify as per dwg & Stock Location: Packing | 0.00 | | | | | | | |
| *160* | | | | | | SHIP TO DAVID S. | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *170* | | | | | | 14/9/9 | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14-6-5
POSITIVE RECALL
EFFE 14.05.15 AUTH
5 DATE 14/08/27
Re inspects to Rev B Dwg

# Picklist Print

*May-15-14 12:35:47 PM*



**Work Order ID:** 119300 *119300*

**Parent Item:** D2261-041 *D2261-041*

**Parent Item Name:** Long Arm Assembly

**Start Date:** 5/15/14 **Required Date:** 5/15/14

**Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:** IPP REV:A 14.05.13 NEW ISSUE DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M304TR0.500W.035 | | Purchased | No | | | 100 | f | 313.4121 | 3 | 4 | | | |
| *M304TR0.500W.035* | | | | | | | | | ** | | FF | 14-05-16 | |
| 304 RD Tube .500 x .035W | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| MAT017 | 313.4121 | | |
| 125513 | 0.0998 | | |
| m126922 | 3 | | |
| m128084 | 70.3123 | | 4 |
| m128495 | 120 | | |
| m128833 | 120 | | |

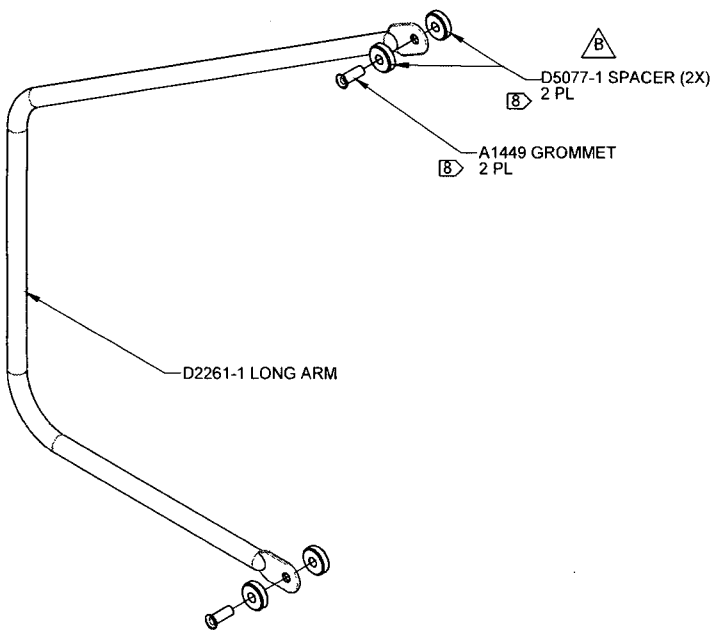
| | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| A1449 | | Purchased | No | | | 140 | Each | 1,171.000 | 2 | 2 | | | |
| *A1449* | | | | | | | | | ** | | FF | 14-06-04 | |
| Grommet | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| ST278 | 1171 | | |
| 1487 | 1171 | | 2 |

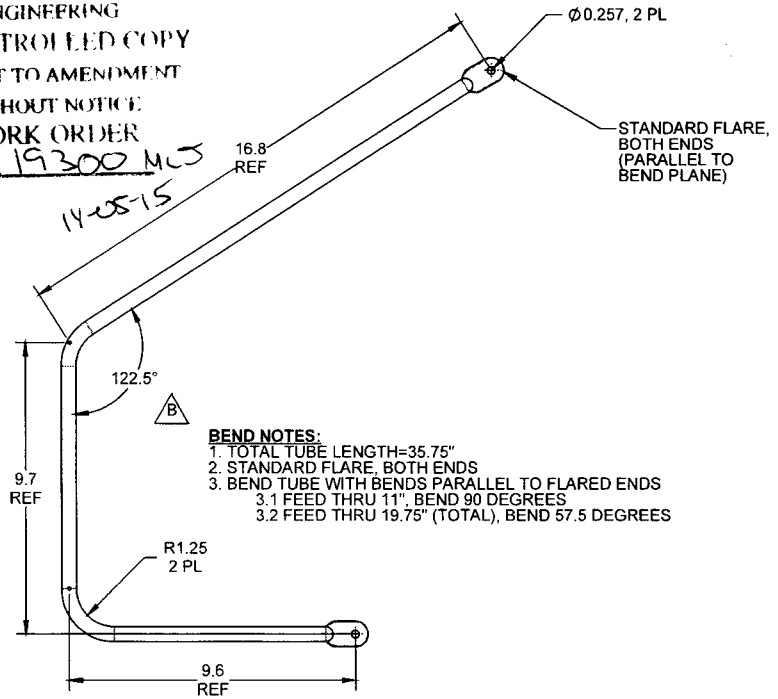
| | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D5077-1 | | Manufactured | No | | | 140 | Each | 0.0000 | 4 | 4 | | | |
| *D5077-1* | | | | 119735 | | | | | ** | 4 | FF | 14-06-04 | |
| Spacer | | | | | | | | | | | | | |

| ITEM | QTY -041 | P/N | DESCRIPTION |
|---|---|---|---|
| | X | D2261-041 | LONG ARM ASSY |
| | | | |
| 1 | 1 | D2261-1 | LONG ARM |
| 2 | 4 | D5077-1 | SPACER |
| 3 | 2 | A1449 | GROMMET |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119300 MCJ
14-05-15




**D2261-041 LONG ARM ASSY**




**D2261-1 LONG ARM**

**BEND NOTES:**
1. TOTAL TUBE LENGTH=35.75"
2. STANDARD FLARE, BOTH ENDS
3. BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS
   3.1 FEED THRU 11", BEND 90 DEGREES
   3.2 FEED THRU 19.75" (TOTAL), BEND 57.5 DEGREES

NOTES:
1) MATERIAL: D2261-1: AISI 304/316 SS SEAMLESS ROUND TUBING PER ASTM A213 OR ASME SA213 OR ASTM A269
   1/2" OD X 0.035" WALL (REF DART SPEC M304TR0.500W.035)
2) FINISH: D2261-1: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
   D2261-041: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY ASSEMBLY WITH DART P/N "D2261-041" USING A REMOVABLE TAG PER DART QSI 044 6.6
7) WEIGHT: 0.17 lbs
8) ASSEMBLE D5077-1 SPACERS (QTY 4), D2261-1 LONG ARM AND A1449 GROMMET (QTY 2) AS SHOWN AND SWAGE GROMMET, 2 PL

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| B | RE-FORMAT DRAWING, D5077-1 WAS D2022-101, 122.5° WAS 120° | DB | 14.03.12 |
| A | NEW ISSUE | MC | 94.08.10 |

APPROVED

| | | |
|---|---|---|
| DESIGN | MC | DART AEROSPACE LTD |
| DRAWN | DB | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | AP | DRAWING NO. D2261 REV. B |
| MFG. APPR. | JLM | SHEET 1 OF 1 |
| APPROVED | MP | TITLE LONG ARM ASSY SCALE NTS |
| DE APPR. | DS | |
| DATE | 14.03.12 | |

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DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

# DART AEROSPACE LTD

Description: Long arm Ass. Work Order: 119300

Inspection Drawing: D2261 Rev: Pb1 Part Number: D 2261-041

## INSPECTION SHEET

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 9.6 | ± 0.030 | 9.616 | ✓ | | SFab-07 | |
| 9.7 | + 0.030 | 9.7 | ~~✓~~ | ~~✓~~ | SFab-07 | |
| 16.8 | ± 0.030 | 16.8 | ~~✓~~ | ~~✓~~ | SFab-07 | |
| 122.5° | 1° | 122.5° | ✓ | | SFab-06 | |

| Measured by: | Checked By: | QC inspector: | Engineering Approval (*if necessary* |
|---|---|---|---|
| FF | DAS 36 9-89 | DAS 27 9-89 | |
| Date 14-05-16 | Date 14/05/16 | Date 14/5/16 | Date |

# Receiving Report

Date: 14/01/28

Batch No: [illegible]

Supplier: MARMON

Dart P/O: [illegible]

Packing Slip: Yes ✓ No ___
Invoice: Yes ___ No ___
Receipt: Cash ___ Cr ___

Release Note Attached: Yes ✓ No ___ N/A ___
Waybill Attached: Yes ___ No ___
Shipment Complete: Yes ✓ No ___ N/A ___
~~QC~~ Inspection 8/Mar/04 N/A ✓
Work Order ___

Discrepancies

| Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|---|---|---|---|---|---|---|
| | | | | | | |
| | | | | | | |
| | | | | | | |

Initials of receiver (if shipment OK) Level 12 ✓

Production/Admin: 14/01/28
Date Received/Costing ___
Initial ___

Location ___

DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

# PURCHASE ORDER

**Purchase Order ID PO22782**

**Purchase Order Date** 1/24/2014
**PO Print Date** 1/24/2014



**Order From :** VC-MAR001

MARMON/KEYSTONE CANADA LTD.
290 CHEMIN DU TREMBLAY
BOUCHERVILLE, QC J4B 5X9
CA

**Ship To :** DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

**Contact Name**
**Vendor Phone** 800 361 8142

**Ship To Contact**
**Ship To Phone**
**Ship Via:** TST ground
**Ship Acct:**

**Buyer** Chantal Lavoie
**Customer POID**
**Customer Tax #** 10127-2607
**Terms** Net 30
**Currency** CAD
**FOB** Destination-Collect

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 3 | M304TR0.250W.049 | 304 Seamless Tubing .250 x .049w | 1/29/2014<br>Yes<br>1/29/2014 | 20.00<br>f | | $0.99 | $19.80 |

MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
AS PER ASTM A213 OR ASME SA213 OR ASTM A269

**Line Total:** **$19.80**

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 4 | M304TR0.500W.035 | 304 RD Tube .500 x .035W | 1/29/2014<br>Yes<br>1/29/2014 | 200.00<br>f | | $0.85 | $170.00 |

MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
AS PER ASTM A213 OR ASME SA213 OR ASTM A269

**Line Total:** **$170.00**

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 5 | M304TR0.750W.049 | 304 RD Tube .750 x .049W | 1/29/2014<br>Yes<br>1/29/2014 | 200.00<br>f | | $1.85 | $370.00 |

MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
AS PER ASTM A213 OR ASME SA213 OR ASTM A269

**Line Total:** **$370.00**

**Note:**

STS- .500- .035- -304L * YTZ2073 * 100066/ * BN3212 * 1/14/2013

# SHANGHAI CRYSTAL PALACE PIPE CO.,LTD

LAO GANG, PUDONG NEW AREA DISTRICT, SHANGHAI, CHINA

CRYSTAL-PALACE

## MILL TEST CERTIFICATE

ISO9001:2008 ;PED Material CERTIFICATE (No.:QAC0021058/A) DATE OF ISSUE: 2012/12/15

| | |
|---|---|
| CUSTOMER: MARMON/KEYSTONE CANADA INC. | CERTIFICATE NO. :2012-9-7-D-1 |
| P.O.NO.: BN3212 | ORDER NO. :2012-09-007-D |
| COMMODITY: STAINLESS STEEL SEAMLESS TUBING. | GRADE : ASTM A213-J0a TP304/TP304L |
| CONDITION: COLD FINISH / SOLUTION TREATED / PICKLED / PLAIN END/ OD POLISHED 400 GRIT | HEAT NO. (YT22073) |

CHEMICAL CONTENTS (WT%)

| ELEMENTS | C | Mn | P | S | Si | Ni | Cr | | |
|---|---|---|---|---|---|---|---|---|---|
| SPECIFICATION | ≤0.035 | ≤2.00 | ≤0.040 | ≤0.030 | ≤0.75 | 8.0~11.0 | 18.0~20.0 | | |
| RESULTS ( LADLE ) | 0.021 | 0.73 | 0.039 | 0.006 | 0.38 | 8.08 | 18.10 | | |

PHYSICAL PROPERTIES

| Dimensions | | | Bundle No. | Pieces | Weight (kg) | 0.2%YS (Mpa) ≥205 | T S (Mpa) ≥515 | EL (%) ≥35 | FLARING TEST | FLATTENING TEST | HARDNESS HRB ≤80 | EDDY CURRENT TEST TO E426 (100%) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| O.D (inch) | W.T (inch) | Length (feet) | | | | | | | | | | |
| 0.500 | 0.035 | 20 | 12-10-143 | 500 | 797 | 305 | 650 | 63.0 | OK | OK | 74 | OK ( DRILLED HOLE ) |
| 0.563 | 0.065 | 20 | 12-10-241 | 50 | 159 | 260 | 690 | 65.0 | OK | OK | 75 | OK ( DRILLED HOLE ) |

REMARKS:
AS PER ASTM A213-10a/ASME SA213-10
WALL THICKNESS TOLERANCE AS PER ASTM A269-10
IN COMPLIANCE TO NACE MR0175-2003
IC TEST TO ASTM A262 PRACTICE E
SOLUTION HEAT TREATMENT :1050°C X 1.5m/min
NO WELD REPAIR WAS PERFORMED
FREE FROM MERCURY CONTAMINATION
COUNTRY OF ORIGIN: CHINA
MILL TEST CERTIFICATE TO EN 10204/3.1
INVOICE NO: YK-12-12-27

1.WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND THE TEST RESULTS ARE IN COMPLIANCE WITH THE TERMS OF THE PURCHASE ORDER OR CONTRACT
2.THE CERTIFICATE SHALL NOT BE REPRODUCED, EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE COMPANY.

SHANGHAI CRYSTAL PALACE PIPE CO.,LTD

QC REVIEWED
JAN 14 2013

DING WEI GUO MANAGER OF QUALITY ASSURANCE DEPARTMENT

**Marmon/Keystone Canada Inc.**
ACIERS SPÉCIALISÉS

290 Chemin du Tremblay
Boucherville QU CAN J4B 5X9
TEL. 514/527-9153
FAX. 450/641-4357

PACKING SLIP

PAGE..: 1
Order : 1142424
Date..: 01/27/2014

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY ON CAN K6A 1K7

SHIPPED TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY ON CAN K6A 1K7

| SHIP VIA | F.O.B. | SALESPERSON | YOUR ORDER NO. |
|---|---|---|---|
| TST OVERLAND #222212 | BOUCHERVILLE | C. Gee | PO22782 |

| | Ordered | Description | Number Pieces | Quantity Shipped | Back Ordered |
|---|---|---|---|---|---|
| | | Fax all papers to Linda Lacelle 613-632-1053 rev:01/11 GD | | | |
| 01 | 20 /FT | STAINLESS STEEL SEAMLESS TUBE<br>SMLS TUBE 316L 1/4 X .049 A213<br>STS .250 .049 316L<br>Tariff Number: 7304.41.19.90<br>Cust. part#.: M304TR0.250W.049<br>HT#.....: 072-1901<br>Total... | 1<br>1 | 20/FT<br>20/FT | |
| 02 | 200 /FT | STAINLESS STEEL SEAMLESS TUBE<br>SMLS TUBE 304L 1/2 X .035 A213<br>STS .500 .035 304L<br>Tariff Number: 7304.41.19.90<br>Cust. part#.: M304TR0.500W.035<br>HT#.....: YT22073<br>Total... | 10<br>10 | 200/FT<br>200/FT | |
| 03 | 200 /FT | STAINLESS STEEL SEAMLESS TUBE<br>SMLS TUBE 304L 3/4 X .049 A213<br>STS .750 .049 304L<br>Tariff Number: 7304.41.99.90<br>Cust. part#.: M304TR0.750W.049<br>HT#.....: YT30540<br>Total... | 10<br>10 | 200/FT<br>200/FT | |
| 04 | 84 /FT | ALUMINUM SMLS TUBE<br>ATS 1.000 .065 D6061<br>Tariff Number: 7608.20.00.00<br>Cust. part#.: M6061T6T1.00W065<br>HT#.....: 17749890<br>Total... | 7<br>7 | 84/FT<br>84/FT | |
| 05 | 96 /FT | ALUMINUM SMLS TUBE<br>ATS .500 .120 D6061<br>Tariff Number: 7608.20.00.00<br>Cust. part#.: M6061T6T0.500W.125<br>HT#.....: F00140746<br>Total... | 8<br>8 | 96/FT<br>96/FT | |

Total Weight.....: 145.3

Packaging:

Customers.: _____

# Purchase Order Receipt Listing



*Tuesday, February 04, 2014 8:49:52 AM*

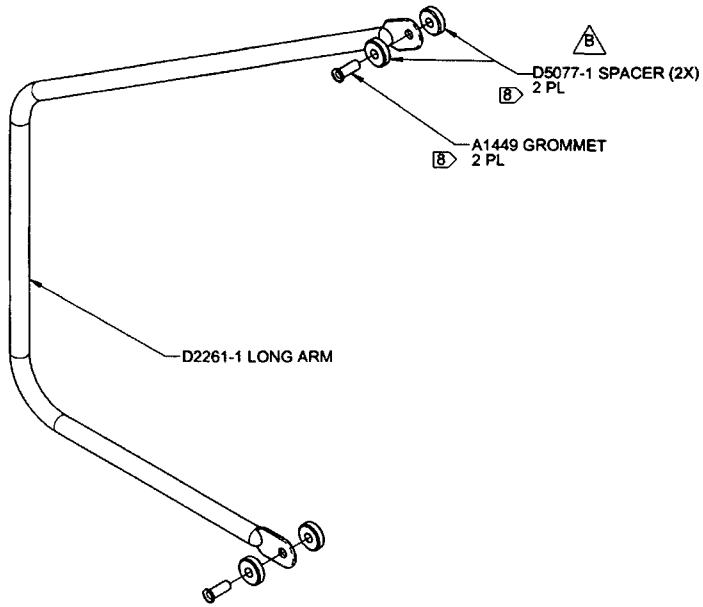
All amounts are calculated in domestic currency.

All Vendors PO ID PO22782 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

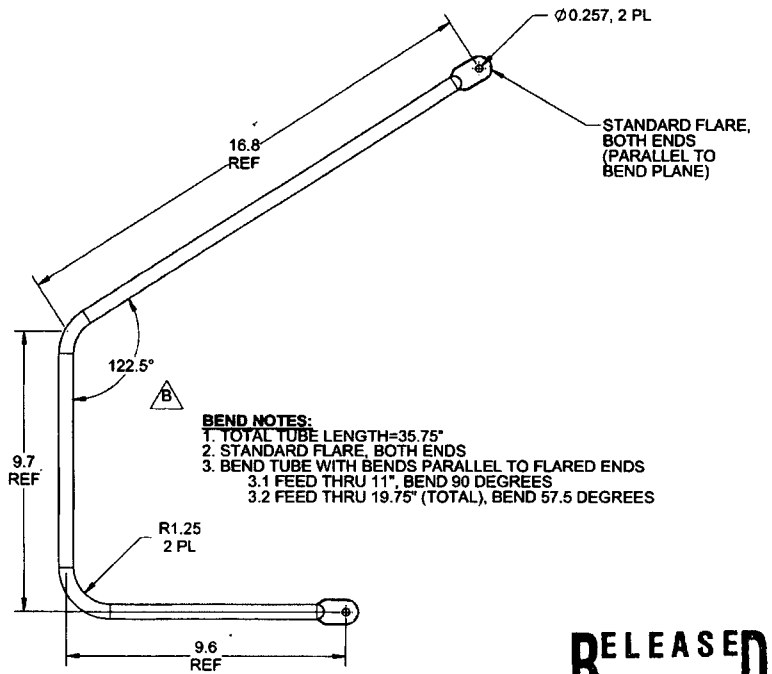
| Purchase Order ID/ Curr Type | Line Nbr/ Insp Req | Project ID | Reference/ Description/ Cert Std | PO U/M / Stock U/M | Required Date Required Qty | Recv Date/ Recv Emp | Recv Qty (PO U/M) | Cost Per Unit/ Recv Value | Inspected Qty/ Rejected Qty (PO U/M) | MRB Qty/ MRB Reject Qty | Book Amt |
|---|---|---|---|---|---|---|---|---|---|---|---|
| **VendorID\Vendor Name** | | | **VC-MAR001 Marmon/Keystone Canada Ltd.** | | | | | | | | |
| PO22782 | 1 | | M6061T6T1.000W065 | f | 1/29/2014 | 1/28/2014 | 84.0000 | $3.32 | 0.0000 | 0 | $279.04 |
| CAD | No | | 6061T6 RD TUBE 1.00 x .065w | f | 84.0000 | DESJ02 | | $279.04 | 0.0000 | 0 | |
| | | | M128084 | | | | | | | | |
| | 2 | | M6061T6T0.500W.125 | f | 1/29/2014 | 1/28/2014 | 96.0000 | $3.57 | 0.0000 | 0 | $343.03 |
| | No | | 6061-T6 RD Tube .500 x .125W | f | 96.0000 | DESJ02 | | $343.03 | 0.0000 | 0 | |
| | | | M128084 | | | | | | | | |
| | 3 | | M304TR0.250W.049 | f | 1/29/2014 | 1/28/2014 | 20.0000 | $0.89 | 0.0000 | 0 | $17.78 |
| | No | | 304 Seamless Tubing .250 x .049w | f | 20.0000 | DESJ02 | | $17.78 | 0.0000 | 0 | |
| | | | M128084 | | | | | | | | |
| | 4 | | M304TR0.500W.035 | f | 1/29/2014 | 1/28/2014 | 200.0000 | $0.76 | 0.0000 | 0 | $152.63 |
| | No | | 304 RD Tube .500 x .035W | f | 200.0000 | DESJ02 | | $152.63 | 0.0000 | 0 | |
| | | | M128084 | | | | | | | | |
| | 5 | | M304TR0.750W.049 | f | 1/29/2014 | 1/28/2014 | 200.0000 | $1.66 | 0.0000 | 0 | $332.19 |
| | No | | 304 RD Tube .750 x .049W | f | 200.0000 | DESJ02 | | $332.19 | 0.0000 | 0 | |
| | | | M128084 | | | | | | | | |
| | 6 | | M6061T6T0.750W.035 | f | 1/30/2014 | 1/30/2014 | 84.0000 | $1.66 | 0.0000 | 0 | $139.52 |
| | No | | 6061T6 RD tubing .750 x .035w | f | 84.0000 | DESJ02 | | $139.52 | 0.0000 | 0 | |
| | | | M128108 | | | | | | | | |

| | |
|---|---|
| **Total Received Quantity:** | 684.0000 |
| **Total Qty to Inspect (PO U/M):** | 0.0000 |
| **Total Reject Quantity:** | 0.0000 |
| **Total Receipt Value:** | $1,264.16 |
| **Total Balance Due Quantity:** | 0.0000 |

| ITEM | QTY -041 | P/N | DESCRIPTION |
|---|---|---|---|
| | X | D2261-041 | LONG ARM ASSY |
| | | | |
| 1 | 1 | D2261-1 | LONG ARM |
| 2 | 4 | D5077-1 | SPACER |
| 3 | 2 | A1449 | GROMMET |




**D2261-041 LONG ARM ASSY**




**BEND NOTES:**
1. TOTAL TUBE LENGTH=35.75"
2. STANDARD FLARE, BOTH ENDS
3. BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS
   3.1 FEED THRU 11", BEND 90 DEGREES
   3.2 FEED THRU 19.75" (TOTAL), BEND 57.5 DEGREES

**D2261-1 LONG ARM**

RELEASED
2014 -08- 27

NOTES:
1) MATERIAL: D2261-1: AISI 304/316 SS SEAMLESS ROUND TUBING PER ASTM A213 OR ASME SA213 OR ASTM A269
1/2" OD X 0.035" WALL (REF DART SPEC M304TR0.500W.035)
2) FINISH: D2261-1: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
D2261-041: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY ASSEMBLY WITH DART P/N "D2261-041" USING A REMOVABLE TAG PER DART QSI 044 6.6
7) WEIGHT: 0.17 lbs
8) ASSEMBLE D5077-1 SPACERS (QTY 4), D2261-1 LONG ARM AND A1449 GROMMET (QTY 2) AS SHOWN AND SWAGE GROMMET, 2 PL

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| B | RE-FORMAT DRAWING, D5077-1 WAS D2022-101, 122.5° WAS 120° | DB | 14.03.12 |
| A | NEW ISSUE | MC | 94.08.10 |

| | | |
|---|---|---|
| DESIGN | MC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| DRAWN | DB | |
| CHECKED | AP | DRAWING NO. D2261 REV. B SHEET 1 OF 1 |
| MFG. APPR. | JLM | |
| APPROVED | MP | TITLE LONG ARM ASSY SCALE NTS |
| DE APPR. | DS | |
| DATE | 14.03.12 | |

APPROVED

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